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D3556-1

Job Sheet 200148



Part No: D3556-1

Part Name: R44 Bearpaw Clamp

Job Qty: 40 pcs ⁵⁵ ₂₁ ^{DAS} ₃₋₈₉

Part Weight: 0 lbs

Job Created: 9/6/19

Due Date: 10/11/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV D IPP Rev:A New Issue 07-03-23 JLM IPP Rev:B 08-07-28 per dwg revb (ecn 08-506) DD verified by:EC IPP Rev C 11.07.14 now in-house EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	40 pcs		10/11/19	0.17	1.52	Waterjet - Flow		2019/11/04
120	QC 8	40 pcs		10/11/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	40 pcs		10/11/19	0.25	0.67	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		

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X

140 QC 5

40
pcs

10/11/19

0.00 0.00

Small Fab - Brake - 3 -
B4B

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

DAS

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40

9-89

150 Packaging 3-1 - Stock -
B4B40
pcs

10/11/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B ✓

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

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ST543 Oscar

160 QC 21 - SA

40
pcs

10/11/19

0.00 0.00

QC 21 - SA - 21 ✓

QC 21 - SA - 70

DAS

21

9-89

ST543

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QC 21 - SA - 53

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Form as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.5200 sf (.038 ea)	100-Waterjet - Flow - 1	S200442 S207058

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	493	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.375inches $\pm$ 0.010	0.385 0.365		
2	Clamp	0.450inches $\pm$ 0.010	0.460 0.440		
3	Clamp	0.750inches $\pm$ 0.030	0.780 0.720		
4	Clamp	1.000inches $\pm$ 0.030	1.030 0.970		
5	Clamp	7.130inches $\pm$ 0.030	7.160 7.100		
6	Clamp	0.257inches + 0.005 - 0.001	0.262 0.256		
7	Clamp	0.375inches $\pm$ 0.010	0.385 0.365		
8	Clamp	6.226inches $\pm$ 0.030	6.256 6.196		
9	Clamp	0.063inches $\pm$ 0.010	0.073 0.053		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube Machining ☐ Large Fab ☐	Cross tube Small Fab ☐ Finishing ☐	Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				
Completed By		Lead hand / Supervisor			
QC / QA Coordinator					